

Work Order ID 65637

January 20, 2011 2:13:32 PM



Page 1

Item ID: D3043-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Weldment LH, A119

Start Date: 1/20/11 Start Qty: 2.00

Cust Item ID:

Required Date: 2/18/11 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: [Signature] Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3043	Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2622-120 extrusion to 120.00" long as per Dwg D3043 using cutting table setup DT8185-G□2-Deburr and bevel ends for welding

11.02.22 2

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

11.02.22 2

120

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Weld 1 End Cap & Mounting Lugs as per OSI 004 & Dwg D3043 Using DT8802□AR AL ROD Batch: M108436 2-Grind Fwd End Cap weld flush
M115928

11.02.23 2

Work Order ID 65637

January 20, 2011 2:13:33 PM



Page 2

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Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				2	0	001/02/23	
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
150 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							

5.00/24

72
44

x2w4 6 11-02-26

155
Q.C.

QC3 - INSPECT Part Finish

11-02-26

2 4

Work Order ID 65637

January 20, 2011 2:13:33 PM

Page 3

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Required Date: 2/18/11 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



Large Fab

Large Fab

Memo

0.00

0.00

11.02.26

2

φ

Large Fab

1-1-Weld 1 End Cap as per QSI 004 & Dwg D3043 AR AL ROD
Batch: 1103436 2-Inspect for foreign object as per QSI 024 3-Grind
Fwd End Cap weld flush

170



QC

Quality Control

QC- Inspect visual per QSI004- Fusion Welds

240

Memo

0.00

0.00

8/10/26

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8/10/26

726H

PTOT

Dart Aerospace Ltd

W/O: 65637 WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
11/02/07	#170	Perm. Change change step # to QCI inspection	<i>[Signature]</i>	11.03.07			<i>S</i> 11/02/07	
11/03/07	#220	wing work as per QSI 0054.4 batch: M116402	<i>JH</i>	11/03/07	<i>2</i>			

Part No: D3043-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65637

January 20, 2011 2:13:34 PM

Page 4

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Cust Item ID:

Required Date: 2/18/11 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

200

QC3- Inspect Part Finish

0.00



QC
Quality Control

Memo

0.00

210

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

HandFinishing
Hand Finishing
QC
Quality Control
N/A
11.02.28
M115951
3200
1.00
1.00

0.00 = 7m-L 11/02/28 (2X)

2 BL 11-2-28

Work Order ID 65637

January 20, 2011 2:13:34 PM



Page 5

Item ID: D3043-041

Accept



Setup Start



Revision ID:

Item Name: Step Weldment LH, A119

Stop



Start Date: 1/20/11 Start Qty: 2.00



Cust Item ID:

Required Date: 2/18/11 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start



QC: Date: SPC (Y/N): Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

Pressure Wash per QSI005 4.3

0.00



HandFinish

Wing Walk

Memo

Batch: 11146402

0.00

x2

φ

PTO=)

Hand Finishing

11.02.28 OK

230

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

OK

m.l 11/03/02

(2x)

240

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

RP 65636

11/3/13

Work Order ID 65637

January 20, 2011 2:13:35 PM

Page 6

Item ID: D3043-041

Accept

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Start Date: 1/20/11 Start Qty: 2.00

Required Date: 2/18/11 Req'd Qty: 2.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

250

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/03/04

ME
11-03-04

Picklist Print

January 20, 2011 2:13:32 PM

Page 1

Work Order ID: 65637

Parent Item: D3043-041

Parent Item Name: Step Weldment LH, A119

Start Date: 1/20/11

Required Date: 2/18/11

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev :A New Issue JLM 05-11-01

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2622-120C

Manufactured

No

120

Each

131.7000

1

2



Step Extrusion

Location

Loc Qty

Loc Code

WA

131.7

55214

1.92

58544

1

61208

4.78

64409

124

D2734

Manufactured

No

120

Each

45.0000

2

4



Step End Plate

Location

Loc Qty

Loc Code

WA

45

62931

45

D3040-1

Manufactured

No

120

Each

42.0000

2

4



Mounting Lug

Location

Loc Qty

Loc Code

WA

42

48239

42

D3040-3

Manufactured

No

100

Each

38.0000

2

4



Mounting Lug

Location

Loc Qty

Loc Code

WA

38

48240

38



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3043	REV. A SHEET 1 OF 2
DATE 01.06.28		TITLE A119 STEP WELDMENT	SCALE NTS
A	01.06.28	NEW ISSUE	

PARTS LIST:

Qty -041	Qty -043	Part Number	Description
X		D3043-041	STEP WELDMENT, LH
	X	D3043-042	STEP WELDMENT, RH
1	1	D2622-120	STEP EXTRUSION
2	2	D3040-1	MOUNTING LUG
2	2	D3040-3	MOUNTING LUG
2	2	D2734	ENDPLATE

NOTES:

- 1) MANUFACTURE FROM D2622-120 EXTRUSION
- 2) WELD PER DART QSI 004. ALL WELDS SHOULD BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004
- 3) FINISH: ACID ETCH & ALODINE ASSEMBLY PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT TOP SURFACE OF STEP TO BOTTOM OF TOP
RADIUS PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

wlb 65637

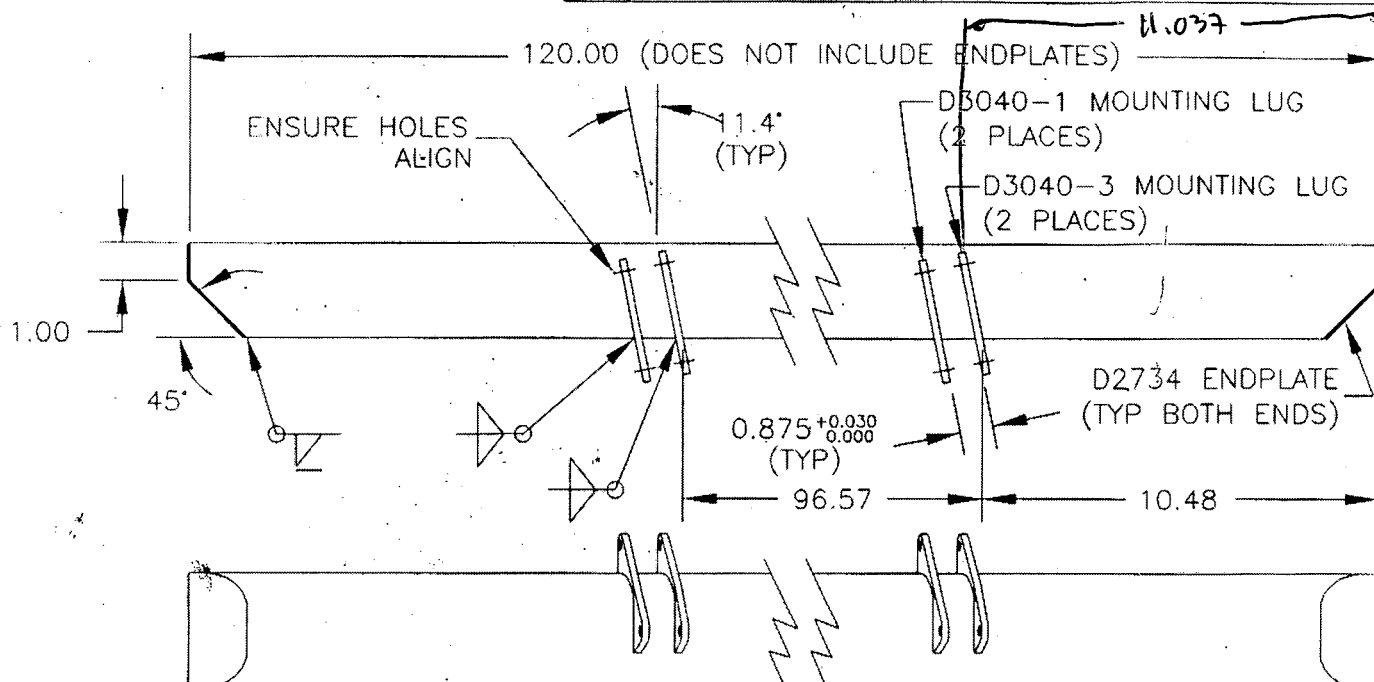
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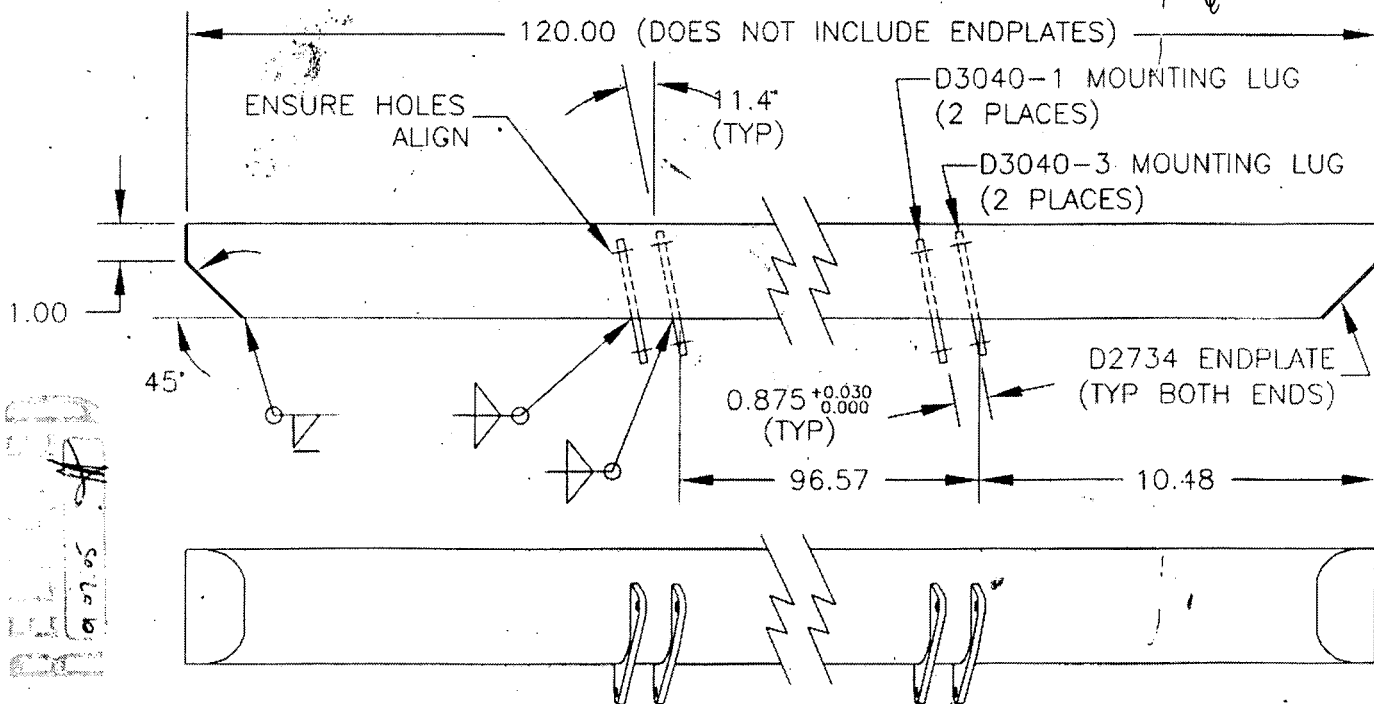
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CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3043	REV. <i>A</i> SHEET 2 OF 2
DATE 01.06.28	TITLE A119 STEP WELDMENT		SCALE 1:5
A	01.06.28	NEW ISSUE	



VIEW A-A: D3043-041 LH STEP WELDMENT



VIEW A-A: D3043-042 RH STEP WELDMENT

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